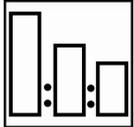


# Autocryl Plus LV

**FOR PROFESSIONAL USE ONLY**

## Description

Two component, high Solid mixing machine based, polyester/acrylic topcoat specifically designed for the refinishing of passenger cars. The system has a VOC content of 420 g/liter and is supported by a full range of ancillary items.



100 Autocryl Plus LV  
50 Autocryl Plus LV Hardener  
10 Autocryl Plus LV Thinner



Use Sikkens measuring stick

**3** Purple

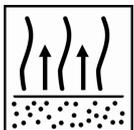


Spray gun set-up:  
1.2-1.3 mm

Application pressure:  
1.7-2.2 bar at the air inlet.



2 x 1 coat



Between coats:  
1-3 minutes at 20°C

Before curing:  
5-7 minutes at 20°C



Autocryl Plus LV Accelerator  
Autocryl Plus LV Thinner

|                              | 20°C     | 60°C       |
|------------------------------|----------|------------|
| Autocryl Plus LV Accelerator | 3 ½ hour | 20 minutes |
| Autocryl Plus LV Thinner     | 5 hours  | 30 minutes |



Use suitable respiratory protection  
Akzo Nobel Car Refinishes recommends the use of a fresh air supply respirator.

Read complete TDS for detailed product information

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## Description

Two component, high Solid mixing machine based, polyester/acrylic topcoat specifically designed for the refinishing of passenger cars. The system has a VOC content of 420 g/liter and is supported by a full range of ancillary items.

## Suitable substrates

Existing finishes  
Polyester laminates  
All Sikkens preparatory products with the exception of Autosurfacers WB

## Product and additives

Autocryl Plus LV

**Hardeners** Autocryl Plus LV Hardener

**Thinners** Autocryl Plus LV Thinner

**Additives** Autocryl Plus LV Accelerator: Spot and panel repairs at 15°C-25°C.  
Autocryl Plus LV Blender (R065): Blending purposes  
Autocryl Structure Paste: See TDS 6.57  
Matting Paste: See TDS S1.08.01

*No plasticiser (Elast-O-Actif) required.*

## Basic raw materials

Autocryl Plus LV: polyester and acrylic resin combination  
Autocryl Plus LV Hardeners: poly isocyanate resins

## Surface preparation



Remove contamination using an appropriate cleaner.



Final sanding step P500  
*For detailed surface preparation see TDS S8.06.02*



Final sanding step P1000  
*For detailed surface preparation see TDS S8.06.02*

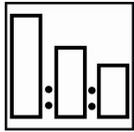


Remove contamination using an appropriate cleaner.  
*Where polyester bodyfiller is exposed, avoid contact with water (e.g. waterborne degreaser).*

# Autocryl Plus LV

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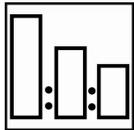
## Mixing



### Standard system

|            |                           |
|------------|---------------------------|
| <b>100</b> | Autocryl Plus LV          |
| <b>50</b>  | Autocryl Plus LV Hardener |
| <b>10</b>  | Autocryl Plus LV Thinner  |

*Stir the mixed MM colors thoroughly before mixing*



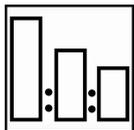
### Accelerated system

|            |                              |
|------------|------------------------------|
| <b>100</b> | Autocryl Plus LV             |
| <b>50</b>  | Autocryl Plus LV Hardener    |
| <b>10</b>  | Autocryl Plus LV Accelerator |

*Stir the mixed MM colors thoroughly before mixing*

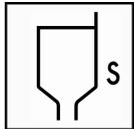
Use Sikkens measuring stick nr. 3

## Blender mixing



|            |   |
|------------|---|
| <b>100</b> | Autocryl Plus LV Blender <b>R065</b>                    |
| <b>50</b>  | Autocryl Plus LV Hardener                               |
| <b>10</b>  | Autocryl Plus LV Thinner / Autocryl Plus LV Accelerator |

## Viscosity



17-21 seconds - DIN Cup 4 at 20°C.

## Spray gun set-up / application



**Spray gun**  
Gravity feed

**Fluid tip – set-up**  
1.2-1.3 mm

**Application pressure**  
1.7-2.2 bar at the spray gun air inlet  
HVLP max 8-10 psi (0.6-0.7 bar) at the air cap

## Application process & blending



Apply a medium closed coat, allowing for a 1-3 minutes flash off time and apply a full coat  
Flash off 5-7 minutes before baking.  
Recoatable with itself within 24 hours  
For blending, see TDS S8.01.01

### Panel blending with Autocryl LV Plus R065.

Apply the colour until achieving opacity, extend the 2<sup>nd</sup> coat slightly beyond the 1<sup>st</sup> coat covering all sanding scratches. Next apply a thin coat of the R065 Blender RTS mixture over the fade-out area of the previous applied colour. This will dissolve the colour and create a better transition from the colour into the blender. Allow for a one minute flash off before applying one full coat of the R065 Blender over the total panel.

- Use the same Hardener / Reducer or Accelerator as in the previous applied colour.

# Autocryl Plus LV

FOR PROFESSIONAL USE ONLY

## Pot-life

|                              |                 |
|------------------------------|-----------------|
| Autocryl Plus LV Thinner     | 2 hours at 20°C |
| Autocryl Plus LV Accelerator | 1 hour at 20°C  |

## Film thickness

45-65 µm

## Drying times

Allow a 5 minute flash-off time at 70°F (20°C) before moving the car into a pre-heated drying oven (booth) at 140°F (60°C). All drying times relate to standard application and object temperature.  
*Consider the time required for the spraybooth air temperature and object to reach 140°F (60°C).*



|                            | 20°C       |               | 60°C       |               |
|----------------------------|------------|---------------|------------|---------------|
|                            | Dust dry   | Dry to handle | Dust dry   | Dry to handle |
| <b>Plus LV Accelerator</b> | 75 minutes | 3.5 hours     | 10 minutes | 20 minutes    |
| <b>Plus LV Thinner</b>     | 1.5 hours  | 5 hours       | 15 minutes | 30 minutes    |



Allow 5 minutes flash-off prior to infra red curing.  
The panel temperature should not exceed above 100°C.  
*For additional information; see TDS S9.01.01*

## Polishability



Ready to be polished after stated air-drying times have been reached, or after a full bake at 60°C object temperature.

## Material usage

By using the recommended application the theoretical material usage is ± 64,5 sq.ft./liter (6 m<sup>2</sup>/liter) RTS mixture.

*The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application techniques, pressure and application circumstances.*

## Cleaning of equipment

Sikkens Solvents or solvent borne Guncleaners

## VOC

### 2004/42/IIB(d)(420)420

The EU limit value for this product (product category: IIB. d) in ready to use form is max. 420 g/liter of VOC.  
The VOC content of this product in ready to use form is max. 420 g/liter.

## Product storage

Product shelf-life is determined when products are stored unopened at 20°C.  
Avoid extreme temperature fluctuation.

- *Product shelf life data see TDS S9.01.02*

# Autocryl Plus LV

FOR PROFESSIONAL USE ONLY

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## FOR PROFESSIONAL USE ONLY

**IMPORTANT NOTE** The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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